.500 303

Work Order ID 68941

Tuesday, April 26, 2011 10:39:52 AM

Item ID: D2652 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bushing

Start Date: 4/26/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 4/29/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Approvals: **Process Plan:** N **Date:** 11-04-26 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2652	Rev A								
100	Hardinge CNC LATHE SMALL	0.00				200	ϕ		
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA252 & DWG D2652 □FOLIO REV: NA □DWG REV: A □2-DEBURR AS REQUIRED								
	CA 11/5/17								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				200	ϕ		
QC	**Memo**	0.00							
Quality Control	CA 11/5/17								
120	QC8- Inspect parts - second check	0.00				200	ϕ		
QC	**Memo**	0.00							
Quality Control	RG 11-5-18								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68941

Tuesday, April 26, 2011 10:39:52 AM

Item ID: D2652
Revision ID:
Item Name: Bushing
Start Date: 4/26/2011 **Start Qty:** 200.00
Required Date: 4/29/2011 **Req'd Qty:** 200.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:	0.00				11/5/19	2		
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00						11/5/19	
QC	Memo	0.00							
Quality Control									

11-05-19
200

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 10:39:59 AM

Work Order ID: 68941

Parent Item: D2652

Parent Item Name: Bushing

Start Date: 4/26/2011 **Required Date:** 4/29/2011

Start Qty: 200.00 **Required Qty:** 200.00

Comments: IPP Rev:B□02.06.13□Now machined in house.□NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	60.5000	0.055	11.57895			
303 Round Bar 0.500"													

Location	Loc Qty	Loc Code
MAT028	60.5	
117143	60.5	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68941
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	.600	✓		SM-9	
0.060	+/-0.005	.060	✓			
Ø0.305	-0.002/+0.000	Ø.304	✓		SM-5	
Ø0.191	+0.005/-0.000	Ø.193	✓			
Ø0.500	+/-0.010	Ø.498	✓			
0.030 x 20°	+/-0.010	.030X20°	✓			
R0.010	+0.010/-0.000	R.015	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/5/18	Date:	11.5.18	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

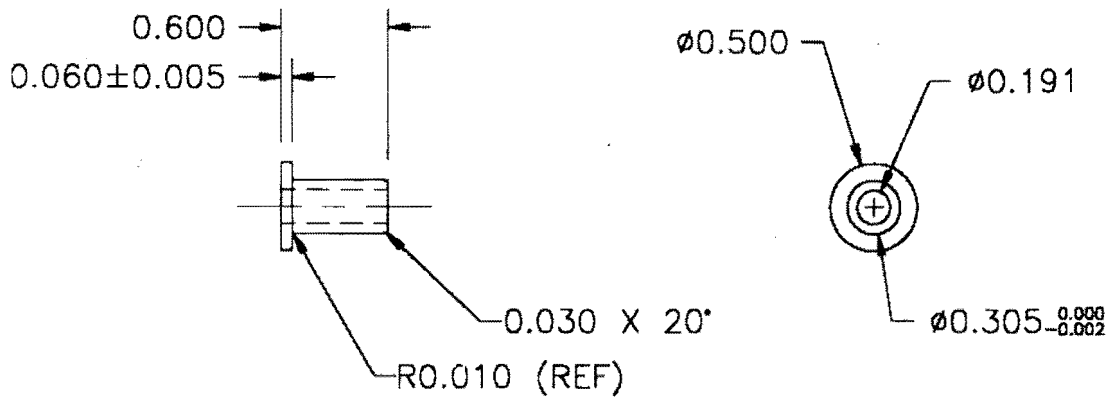
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1

DART

QA COPY ISSUED

RELEASED
97/04/25 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48911

11-09-26

MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries